

Date: Tuesday, 17/02/2009 10:19:17 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEB
 Job Number : 45835
 Estimate Number : 13597
 P.O. Number :
 This Issue : 17/02/2009 S.O. No. :
 Prsht Rev. : NC Part Number : D38153
 First Issue : / / Type : SMALL /MED FAB Drawing Number : D3815 REV A
 Previous Run : Drawing Revision : A
 Written By : Due Date : 24/02/2009 Qty: 20 Um: Each
 Checked & Approved By : MD 09-02-17
 Comment : Est Rev:A 08-09-18 new issue DD verified by:EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M2024T3S063 2024-T3 .063 sheet



Comment: Qty.: 0.5177 sf(s)/Unit Total : 10.3530 sf(s)
 2024-T3 .063 sheet
 batch: 110920 18 9-2-27

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D3815
 Dwg Rev: A
 Prog Rev: A

18 9-2-27

2-Deburr if necessary

18 9-2-27

M-1 (24) (24)
09/02/02

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



18 9-2-27



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

09/02/27 (24)

5.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MD

09/02/02

(24)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: ~ Tuesday, 17/02/2009 10:19:17 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEB

Job Number: 45835

Part Number: D38153

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



24

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BL 09-03-02

7.0

PACKAGING 1

PACKAGING RESOURCE #1



209

Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock

Location: *Slvie*

9/3/2

SP

8.0

QC21

FINAL INSPECTION/W/O RELEASE



09/03/03

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 09-03-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 45835
Description: WEB		Part Number: D3815-3
Inspection Dwg: D3815-3 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .128	+ .005 - .001	.130	X			
Ø .172	+ .005 - .001	.175	X			
1.05	+/- .030	1.048	X			
.95	+/- .030	.95	X			
1.50	+/- .030	1.513	X			
1.05	+/- .030	1.048	X			
3.08	+/- .030	3.084	X			
Ø .098	+/- .001 - .001	.101	X			
6.63	+/- .030	6.633	X			
5.05	+/- .030	5.059	X			
1.97	+/- .030	1.975	X			
4.58	+/- .030	4.583	X			
.90	+/- .030	.907	X			
.30	+/- .030	.300	X			
.75	+/- .030	.752	X			
.50	+/- .030	.508	X			
11.98	+/- .030	11.991	X			
1.00	+/- .030	.999	X			
13.00	+/- .030	13.000	X			
1.00	+/- .030	.999	X			
15.50	+/- .030	15.50	X			
1.063	+/- .010	1.063	X			

Measured by: HB	Audited by: S	Prototype Approval: N/A
Date: 9-2-07	Date: 09/02/07	Date: 9/2/07

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

